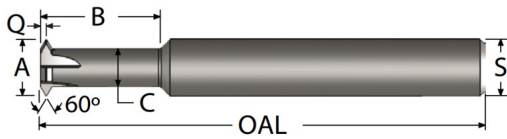


# SOLID CARBIDE ALTiN+ COATED THREAD MILLS FOR UN (INCH) AND METRIC INTERNAL & EXTERNAL THREADS



- Single profile solid carbide provides maximum tool rigidity
- ALTiN+ coating for long tool life (uncoated also available)
- Cuts UNC, UNF, UNEF, UNS, AND coarse & fine Metric threads
- Cuts UNJ threads (internal only)
- Long reach tools and tools for other diameters & pitches also available

| ORDER #       | MINIMUM INTERNAL THREAD* UN | MIN. INTERNAL THREAD* METRIC | "A" TOOL DIA. | "B" LENGTH OF CUT | "C" NECK DIA. | "Q" LENGTH | "S" SHANK DIA. | OAL  | FLUTES | INTERNAL TPI RANGE | EXTERNAL TPI RANGE | METRIC PITCH RANGE (MM) | STOCKED? |
|---------------|-----------------------------|------------------------------|---------------|-------------------|---------------|------------|----------------|------|--------|--------------------|--------------------|-------------------------|----------|
| SCISPTM059LA  | #2 (56-80 TPI)              | M2 (0.30-0.45)               | 0.059         | 0.200             | 0.034         | 0.008      | 0.1250         | 1.50 | 3      | 56 to 80           | 72 to 80           | 0.30 to 0.45            | YES      |
| SCISPTM080LA  | #4 (40-80 TPI)              | M3 (0.40-0.60)               | 0.080         | 0.300             | 0.045         | 0.011      | 0.1875         | 2.00 | 3      | 40 to 80           | 48 to 80           | 0.40 to 0.60            | YES      |
| SCISPTM098MLA | #6 (32-56 TPI)              | M3.5 (0.40-0.80)             | 0.098         | 0.330             | 0.050         | 0.015      | 0.1875         | 2.00 | 3      | 32 to 56           | 36 to 56           | 0.40 to 0.80            | YES      |
| SCISPTM138MLA | #10 (24-48 TPI)             | M5 (0.45-1.00)               | 0.138         | 0.500             | 0.075         | 0.020      | 0.1875         | 2.00 | 3      | 24 to 48           | 28 to 48           | 0.45 to 1.00            | YES      |
| SCISPTM160LA  | #12 (20-48 TPI)             | M6 (0.50-1.25)               | 0.160         | 0.650             | 0.080         | 0.025      | 0.1875         | 2.00 | 3      | 20 to 48           | 24 to 48           | 0.50 to 1.25            | YES      |
| SCISPTM182LA  | 1/4 (18-48 TPI)             | M7 (0.50-1.25)               | 0.182         | 0.650             | 0.104         | 0.025      | 0.2500         | 2.50 | 4      | 18 to 48           | 24 to 48           | 0.50 to 1.25            | YES      |
| SCISPTM240LA  | 5/16 (16-48 TPI)            | M8 (0.50-1.50)               | 0.240         | 0.800             | 0.153         | 0.028      | 0.2500         | 2.50 | 4      | 16 to 48           | 20 to 48           | 0.50 to 1.50            | YES      |
| SCISPTM290LA  | 3/8 (14-48 TPI)             | M10 (0.75-1.75)              | 0.290         | 1.000             | 0.192         | 0.031      | 0.3750         | 3.00 | 4      | 14 to 48           | 18 to 48           | 0.75 to 1.75            | YES      |
| SCISPTM372LA  | 1/2 (12-48 TPI)             | M12 (0.80-2.00)              | 0.372         | 1.250             | 0.240         | 0.041      | 0.3750         | 3.00 | 4      | 12 to 48           | 12 to 48           | 0.80 to 2.00            | YES      |
| SCISPTM488LA  | 5/8 (11-32 TPI)             | M16 (0.80-2.50)              | 0.488         | 1.350             | 0.340         | 0.046      | 0.5000         | 3.50 | 5      | 11 to 32           | 11 to 32           | 0.80 to 2.50            | YES      |
| SCISPTM595LA  | 3/4 (10-32 TPI)             | M20 (1.00-2.50)              | 0.595         | 2.000             | 0.430         | 0.051      | 0.6250         | 4.00 | 6      | 10 to 32           | 10 to 32           | 1.00 to 2.50            | YES      |
| SCISPTM695LA  | 7/8 (8-24 TPI)              | M24 (1.00-3.00)              | 0.695         | 2.500             | 0.490         | 0.063      | 0.7500         | 5.00 | 6      | 8 to 24            | 8 to 24            | 1.00 to 3.00            | YES      |

**\*\*\* ALL TOOLS ARE IN STOCK AT TOOL & CUTTER! \*\*\***

\*Single profile thread mills can cut any larger diameter internal thread within the TPI limits

## THREAD MILL SPEEDS AND FEEDS CHART

| MATERIAL                       | HB/Rc  | SPEED SFM* UNCOATED | SPEED SFM ALTiN+ | FEED ( INCHES PER TOOTH) |                          |                         |             |             |             |
|--------------------------------|--------|---------------------|------------------|--------------------------|--------------------------|-------------------------|-------------|-------------|-------------|
|                                |        |                     |                  | TOOL DIAMETER            |                          |                         |             |             |             |
|                                |        |                     |                  | .032 - .056              | .059 - .090              | .100 - .190             | .200 - .350 | .370 - .595 | .600+       |
| CAST IRON                      | 160 HB | 100-220             | 200-425          | .0004-.001               | .0004-.0008              | .0004-.0014             | .0004-.002  | .0004-.0035 | .0004-.006  |
| CARBON STEEL                   | 18 Rc  | 100-200             | 190-425          | .0003-.001               | .0003-.0008              | .0003-.0014             | .0003-.002  | .0003-.005  | .0003-.006  |
| ALLOY STEEL                    | 20 Rc  | 80-200              | 200-375          | .0003-.001<br>2 Passes   | .0003-.0008<br>3 Passes  | .0003-.0014             | .0003-.0024 | .0003-.005  | .0003-.006  |
| TOOL STEEL                     | 20 Rc  | 80-175              | 175-250          | .0003-.0004<br>2 Passes  | .0003-0.0005<br>3 Passes | .0003-.0005             | .0003-.0009 | .0003-.0026 | .0003-.004  |
| 300 STAINLESS STEEL            | 150 HB | 90-120              | 120-255          | .0003-.0005<br>2 Passes  | .0003-0.0006<br>3 Passes | .0003-.0007             | .0003-.002  | .0003-.0035 | .0003-.0045 |
| 400 STAINLESS STEEL            | 195 HB | 90-150              | 140-375          | .0003-.0005<br>2 Passes  | .0003-.0006<br>3 Passes  | .0003-.0007             | .0003-.002  | .0003-.0026 | .0003-.0045 |
| HIGH TEMP ALLOY (Ni & Co BASE) | 20 Rc  | 50-125              | 100-125          | .0003-.0004<br>3 Passes  | .0003-.00045<br>3 Passes | .0003-.0005<br>2 Passes | .0003-.0009 | .0003-.0026 | .0003-.004  |
| TITANIUM                       | 25 Rc  | 50-130              | 100-170          | .0003-.0004<br>3 Passes  | .0003-.00045<br>3 Passes | .0003-.001<br>2 Passes  | .0003-.0009 | .0003-.0015 | .0003-.003  |
| HEAT TREATED ALLOYS (38-45Rc)  | 40 Rc  | 50-90               | 90-150           | .0003-.0004<br>3 Passes  | .0003-.00045<br>3 Passes | .0003-.0005<br>2 Passes | .0003-.0008 | .0003-.001  | .0003-.0025 |
| ALUMINUM                       | 100 HB | 100-800             | 100-1200         | .0005-.0015              | .0005-.002               | .0005-.0025             | .0005-.003  | .0005-.006  | .0005-.009  |
| BRASS, ZINC                    | 80 HB  | 200-350             | 200-750          | .0005-.0015              | .0005-.002               | .0005-.0025             | .0005-.003  | .0005-.006  | .0005-.009  |

\*SFM = Surface Feet per Minute

Parameters are a starting point based on machinability rating at hardness listed. Check machinability rating of the material to be machined and adjust accordingly.

**INTRODUCTORY OFFER!**  
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